

Work Order ID 132325

Thursday, May 07, 2015 9:01:47 AM

Page 1

Item ID: D2646

Revision ID:

Item Name: Aft Cap

Start Date: 5/7/2015

Required Date: 5/7/2015

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

DATE: MAR 07 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2646

Rev C

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 28394 1-Spin as per Dwg D2646 2-Material release
note required
Vendor: Sieg's Manufacturing

CZ MAR 07 2015

16

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

16x 805-05-15

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

16

DAG
38
9-89

MAY 20 2015

Work Order ID 132325***132325***

Thursday, May 07, 2015 9:01:47 AM

Item ID: D2646

Accept

N900040100

Setup Start

***1**

Revision ID:

Item Name: Aft Cap

Stop

NS

Start Date: 5/7/2015

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Drill using DT8026 as per Dwg D2646.2-Open holes to .297 as per Dwg
D2646.3-Deburr

16

FF

MAY 20 2015

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(16)

DAS
38
9-89

MAY 20 2015

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

16

7

05/05/31

Work Order ID 132325

Thursday, May 07, 2015 9:01:47 AM

132325

Page 3

Item ID: D2646

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Cap

Stop ***NS2***

Start Date: 5/7/2015

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

Memo

0.00

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Primer : 132122

16

Paint : 128955

Clear : 129271

DAS
41
9-99

15-6-14

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

(16)

DAS
38
9-99

JUN 16 2015

180

Small Fab

0.00

180

Small Fab

Small Fab

Memo

0.00

Install inserts as per Dwg D2646

x16 of Ill 13/06/17

Work Order ID 132325

Thursday, May 07, 2015 9:01:47 AM

132325

Page 4

Item ID: D2646

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Cap

Start Date: 5/7/2015

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

16 ϕ 15-6-17

DAS 34 989

200

Identify as per dwg & Stock Location: FP-001

0.00

200

Packaging

Memo

0.00

Packaging

LOCATION : FP001

116 ϕ 15-6-17

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCS

JUN 18 2015

15-06-18

Thursday, May 07, 2015 9:01:51 AM

132325

D2646

Required Date: 5/7/2015

Required Qty: 10.00

IPP: G05.08.22Hole size revised in Step 5KJ/JLM

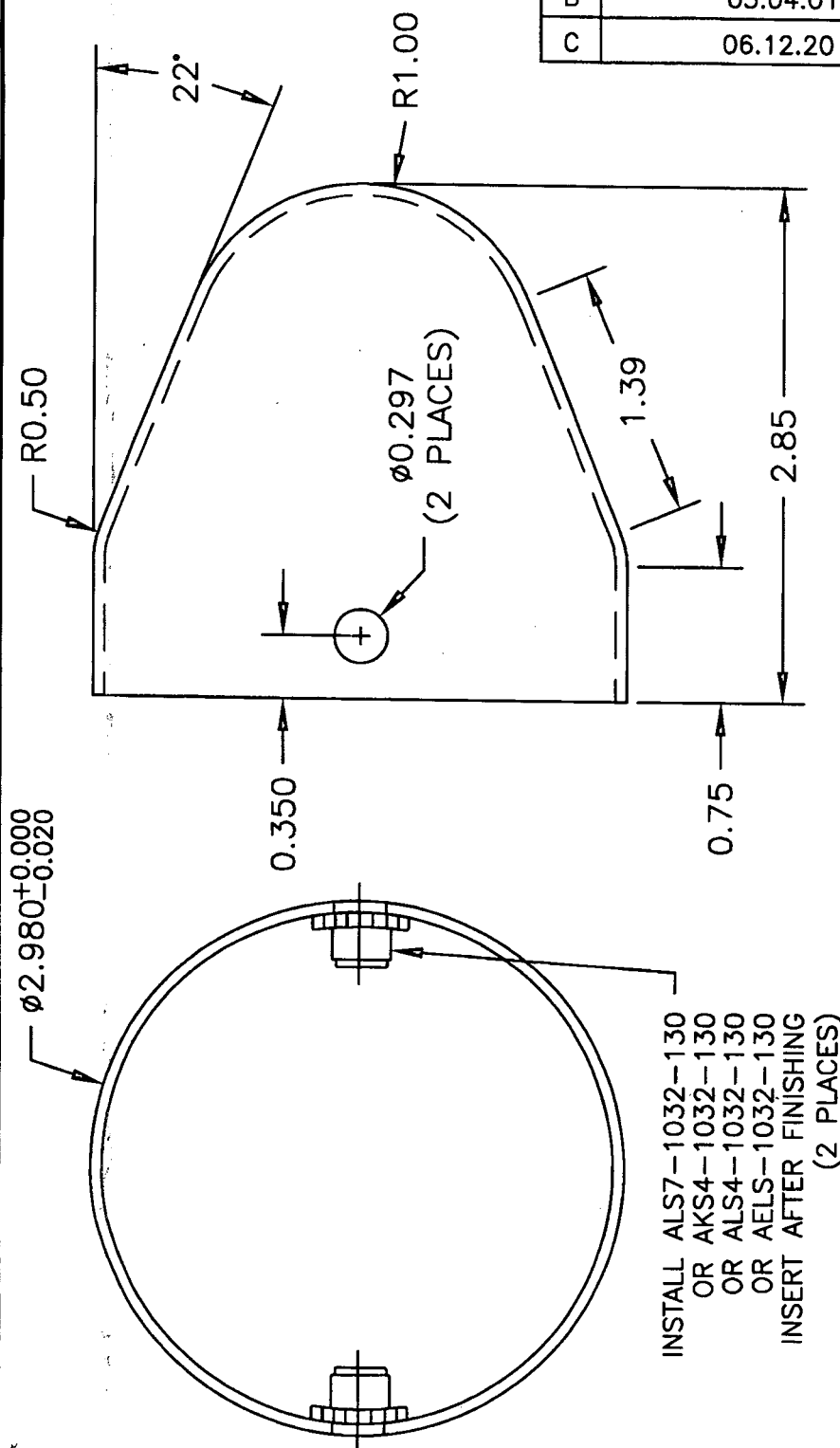
IPP Rev:H Changed Inserts 07-02-19 JLM

IPP rev I	changed inserts	07.06.11	EC
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[illegible]



DESIGN DS		DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]		DRAWING NO. D2646	REV. C SHEET 1 OF 1
DATE 06.12.20			TITLE AFT CAP	SCALE 1:1
A	97.03.25		NEW ISSUE	
B	05.04.01		CHANGE TO CLOSED INSERTS	
C	06.12.20		CHANGE TO OPEN ENDED INSERTS	



RELEASED
07.02.12 *[Signature]*

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CL 15/05/07
W/O: 132325

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28394**

Purchase Order Date 5/7/2015

PO Print Date 5/7/2015

Page Number 1 of 2

Order From :

SIEG'S MANUFACTURING LTD.
6236 - 205 STREET
LANGLEY, BC V2Y 1N7
CA

VC-SIE001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FC

Contact Name

Vendor Phone 604 530 7455

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	D2646P	Aft Cap	5/22/2015 Yes 5/22/2015		16.00 Each	\$6.70	\$107.20
AS PER DWG D2646 REV. C B132325		8P15-05-15					
Line Total:							\$107.20
2	D2646P	Aft Cap	5/22/2015 Yes 5/22/2015		34.00 Each	\$6.70	\$227.80
AS PER DWG D2646 REV. C B132326							

8015-05-15

Note:

5/7/2015



Sieg's Manufacturing Ltd.

Quality Metal Spinning & Metal Fabricating
6236 205 Street, Langley, BC, Canada V2Y 1N7
Phone: (604)530 7455 Fax: (604)530-7490
www.siegsmf.com

Packing Slip

Packing Slip No.: 45392
Date: 05/13/2015
Page: 1

Sold to: DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	Ship to: DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
Order No.: 28394	Sold By: LOWEY, ARLA
Shipped By:	Ship Date: 05/13/2015
Tracking No.:	

Item No.	Unit	Description	Quantity	Backorder quantity
D2646	Each	Aft Cap	160X SP15-05-15 50	

Comment:



Sieg's Manufacturing Ltd.

6236 205 Street Langley, B.C. Canada V2Y 1N7

Ph#: (604)530-7455 fax#: (604)530-7490

arla@siegsmfg.com

INSPECTION REPORT

Date: May 13, 2015

Customer: Dart Areospace

Packing Slip: 45392

Part#:	Quantity	Material	Check holes	Insp. By.
D2646	5076X	14g 1100	N/a	AL

8015-05-15

Notes:

Material Certification Attached: ____YES____



ThyssenKrupp Materials NA 19044 95A Avenue Surrey BC V4N 4P2

DELIVERY NOTE

SIEGS MANUFACTURING LTD.
6236 205 ST
LANGLEY BC V2Y 1N7



DATE:	01/06/2014
DOC. NO:	2402875712*
BOL. NO:	2402875712
ORDER NO:	1401788868
YOUR P/O:	1514
CUSTOMER NO:	10007550
Route:	B9MI5
CONTACT:	Timothy Skidmore
TEL:	800-926-2600
FAX:	888-926-2600
EMAIL:	timothy.skidmore@thyssenkrupp.com

PST-1001-1682 OLD PST# R292133

We deliver at your own risk and account in accordance with our general delivery and payment terms.

ITEM	DESCRIPTION	NET QTY1 / QTY2	PACKAGE NO.
0010	ALFLR01243	100 PC	1003901956
	1100 Aluminum - O Sheet	4,267.469 lb	1003901957
	0.06300 X Width 48.0000 X Length 144		
	Nominal Chemistry/Act Physical		
	Standard Packaging		
	TAGNUMBER QUANTITY UOM VENDOR VENDORPO HEAT/LOT PCS		
	1003692716 74 PC SKANA ALU 5400197413 11A711 74		
	ROHS COMPLIANT;ASTM B 209 2010		
	1003793591 26 PC SKANA ALU 5400200310 11B224 26		
	ROHS COMPLIANT;ASTM B 209 2010		

Total Gross Weight

4517.469 lb

All items, not declared as partial delivery, are final quantities.

Delivery Terms: PPD gem. Incoterms 2000 Prepaid

CERTIFICATION OF COMPLIANCE

We hereby certify that mercury or any of its compounds are not used in the processing and distribution of our products. The products we distribute are not hazardous in their received state.

For MSDS sheets go to www.copperandbrass.com. We hereby certify that the material above complies with the above specifications

John R Zambetti - Director of Quality Assurance

ThyssenKrupp Materials NA
Copper and Brass Sales Division
19044 95A Avenue
SURREY BC V4N 4P2
Tel.: +16048823493 Fax: +16048820686



Order number	Ord-pos	Del-pos	Part description
Customer PO	PO date	Quantity	Customer Part
MTR header	MTR type	Search criteria	Heat lot
			Sample number
C8A/1401788868	000020	900001	1100 Aluminum - O Sheet 0.06300 X Width
1514	12/18/2013	74 ST	
Att_001.PDF	NCAP	930230267220130003	11A711
C8A/1401788868	000020	900002	1100 Aluminum - O Sheet 0.06300 X Width
1514	12/18/2013	26 ST	
Att_002.PDF	NCAP	930235185120130004	11B224

Delivery number
2402875712
Date
12/19/2013

SIEGS MANUFACTURING LTD.
6236 205 ST
LANGLEY V2Y 1N7
CANADA



Skana Aluminum Co
Rolling Mill - Certified Metal
Certification of Properties and Analysis

Physical test: **11A711** Aluminum Alloy: **1100** Temper: **-O-** Thickness: **.0630**

Tested For: **Copper and Brass Sales**

6156 PO No: **5400197413-R01**

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..		0.05	..	..	..	..	..	..		
Max Range	.95 Si	+Fe	0.20	0.05	..	..	..	0.1	..	0.05	

Coil Ref. No.	1	2	3	4	5						
Tensile Strength KSI	13.28	13.38	13.44	13.55	13.31						
Yield Strength KSI	4.34	4.25	4.46	4.58	4.47						
% Elong. in 2 in.	31.80	31.90	32.70	31.40	30.30						

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Remarks: Tested By: **RJD**

Certified Date: **10 Oct 2013**

Certified By
Lab Manager

Kenia Compton

RJD .063 X 48.000 MF 5/5

ITEM # ALFLR01243

MEETS/EXCEEDS ASTM B209-10 SPEC

BLANKS: COILS TO PRESSROOM

Thursday, October 10, 2013

Melted/Manufactured in USA

QF 824-1-1

Page 1 of 1

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

Del.: 2402875712

CstAr

CstOr 1514

Wgt.: 3,157.927 LB

Date 12/19/2013

John R. Zambetti

Skana Aluminum Company

Rolling Mill - Certified Metal

Certification of Properties and Analysis

Physical test: 11A711 Aluminum Alloy: 1100 Temper: -O- Thickness: .0630
 Tested For: Copper and Brass Sales 6156 PO No: 5400197413-R01

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..		0.05	..	..	..	..	..	..		
Max Range	.95 Si	+ Fe	0.20	0.05	..	..	..	0.1	..	0.05	

1	13.28	4.34	31.80	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.44	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

2	13.38	4.25	31.90	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

3	13.44	4.46	32.70	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

4	13.55	4.58	31.40	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.44	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

5	13.31	4.47	30.30	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.17	.43	.10	.00	.00	.00	.00	.00	.01	.00

Al

99.20

Remarks: Tested By: RJD Certified Date: 10 Oct 2013 Certified By: Lenna Compton
 RJD .063 X 48.000 MF 5/5
 ITEM # ALFLR01243
 MEETS/EXCEEDS ASTM B209-10: SPEC
 BLANKS: COILS TO PRESSROOM

Thursday, October 10, 2013

Melted/Manufactured in USA QF 824-1-2

Page 1 of 2

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

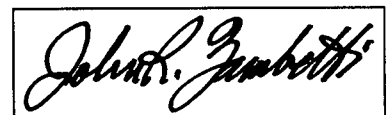
Del.: 2402875712

CstAr

CstOr 1514

Wgt.: 3,157.927 LB

Date 12/19/2013





Skana Aluminum Co
Rolling Mill - Certified Metal
Certification of Properties and Analysis

Physical test: 11B224 Aluminum Alloy: 1100 Temper: -O- Thickness: .0630

Tested For: Copper and Brass Sales

6156 PO No: 5400200310-R01

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..		0.05	..	..	..	..	..	..		
Max Range	.95 Si	+ Fe	0.20	0.05	..	..	..	0.1	..	0.05	

Coil Ref. No.	1	2	3	4	5						
Tensile Strength KSI	14.10	14.06	14.04	14.06	14.14						
Yield Strength KSI	5.29	5.14	5.07	5.07	4.93						
% Elong. in 2 in.	30.80	30.40	30.70	31.30	32.30						
Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											
Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											
Coil Ref. No.											
Tensile Strength KSI											
Yield Strength KSI											
% Elong. in 2 in.											

Remarks: Tested By: RJD

Certified Date: 21 Nov 2013

Certified By
Lab Manager

RJD .063 X 48.000 MF 5/5

ITEM # ALFLR01243

MEETS/EXCEEDS ASTM B209-10 SPEC

BLANKS: COILS TO PRESSROOM

Thursday, November 21, 2013

Melted/Manufactured in USA

QF 824-1-1

Page 1 of 1

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

Del.: 2402875712

CstAr

CstOr 1514

Wgt.: 1,109.542 LB

Date 12/19/2013

Skana Aluminum Company

Rolling Mill - Certified Metal

Certification of Properties and Analysis

Physical test: 11B224 Aluminum Alloy: 1100 Temper: -O- Thickness: .0630

Tested For: Copper and Brass Sales

6156 PO No: 5400200310-R01

Chemical	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others	Al
Min Range	..	..	0.05	..	..	..	..	..	..	..	..
Max Range	.95 Si	+ Fe	0.20	0.05	..	..	..	0.1	..	0.05	..

1	14.10	5.29	30.80	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

2	14.06	5.14	30.40	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

3	14.04	5.07	30.70	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

4	14.06	5.07	31.30	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

5	14.14	4.93	32.30	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Others
				.18	.43	.12	.02	.01	.00	.00	.00	.01	.00

Al

99.20

Remarks: Tested By: RJD

Certified Date: 21 Nov 2013

Certified By:

Lab Manager

Robert A. [Signature]

RJD .063 X 48.000 MF 5/5

ITEM # ALFLR01243

MEETS/EXCEEDS ASTM B209-10 SPEC

BLANKS: COILS TO PRESSROOM

Thursday, November 21, 2013

Melted/Manufactured in USA QF 824-1-2

Page 1 of 2

From: Copper and Brass Sales CA

Cust. SIEGS MANUFACTURING LTD.

Del.: 2402875712

CstAr

CstOr 1514

Wgt.: 1,109.542 LB

Date 12/19/2013

John R. Zambetti

COPPER AND BRASS SALES**MATERIAL TYPE****ALUMINIUM ALLOYS****PRODUCT DESIGNATION****1100 1350 3003 3004 3105 5005 5083 5086 5182 5454 6061 6063****"WARNING"**

SMALL CHIPS, FINE TURNINGS AND DUST MAY IGNITE READILY. EXPLOSIONPOTENTIAL MAY BE PRESENT WHEN:DUST OR FINES ARE DISPERSED IN THE AIR; FINE, DUST OR MOLTEN ALUMINUMARE IN CONTACT WITH CERTAINMETAL OXIDES; OR, CHIPS, FINES, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH WATER OR MOISTURE. KEEP AWAY FROM IGNITION SOURCE. USE EXPLOSION- PROOF VENTILATION. KEEP MATERIAL DRY.

INHALING LARGE AMOUNTS OF COPPER, MAGNESIUM OXIDE, MANGANESE OXIDE, AND ZINC OXIDE FUMES OR DUST MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS. CHRONIC OVEREXPOUSURE TO COPPER MAY CAUSE THICKENING OF THE SKIN; AND SKIN,TEETH,AND HAIR DISCOLORATION. CHRONIC OVEREXPOUSURE TO MANGANESE DUST CAN CAUSE CENTRAL NERVOUS SYSTEM DAMAGE,SCARRING OF THE LUNGS AND REPRODUCTIVE HARM IN MALES.TARGET ORGAN IS PRIMARILY THE LUNG,BUT REPEATED HIGH EXPOSURE CAN ALSO AFFECT THE LIVER.CHRONIC OVEREXPOSURE TO TIN DUST OR IRON OXIDE DUST/FUME MAY CAUSE LUNG SIDEROSIS.CHRONIC OVEREXPOUSURE TO SILICON DUST CAN CAUSE CHRONIC BRONCHITIS.

THIS PRODUCT ALSO CONTAINS LEAD AND CHROMIUM COMPOUNDS.LEAD IS KNOWN TO CAUSE REPRODUCTIVE TOXICITY AND IS A KNOWN CARCINOGEN.EXPOSURE TO CHROMIUM DUST OR FUME MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS AND KIDNEY AND KIDNEY AND LIVER DAMAGE.UNDER HIGH TEMPERATURES,HEXAVALENT CHROMIUM MAY BE PRODUCED,IF INTHE INSOLUBLE FORM,IT IS A CONFIRMED HUMAN CARCINOGEN. (CALIFORNIA PROPOSITION 65). IF COATED WITH OIL,MAY CAUSE SKIN IRRITATION/DERMATITIS BY CONTACT. WELDING FUME IS LISTED AS A POSSIBLE CARCINOGENIC TO HUMANS.READ THE ALUMINUM/ALUMINUM ALLOYS MATERIAL SAFETY DATA SHEET(MSDS) ON FILE WITH YOUR EMPLOYER BEFORE WORKING WITH THIS MATERIAL.

* If processing or recycling produces particulate,use exhaust ventilation or other controls designed to prevent exposure to workers. Examples of such activities include melting, welding,grinding,abrasive sawing,sanding and polishing.Any activity which abrades the surface of this material can generate airborne particulate.Use appropriate NIOSH approved respiratory protection (P95; P100 for lead with, quantitative fit testing required) if exposures exceed the permissible limits.

* The Occupational Safety and Health Administration (OSHA) have set mandatory limits on occupational exposures.

* Aluminum, in solid form and as contained in finished products presents no special health risk.

* Sold for manufacturing purposes only.This product can be recycled; contact your sales representative.

The Occupational Safety and Health Administration require employers to provide training in the proper use of this product.

For additional information, call or write to Copper and Brass Sales,22355 West Eleven Mile Road, Southfield, MI 48033,telephone248-233-5600, or visit our web site @ www.copperandbrass.com.